

Work Order ID 76359

76359

Page 1

November-09-11 2:33:40 PM

Item ID: D3016-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Frame Assembly
 Start Date: 09/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 25/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3016	RevA / DEO A-1

100 Weld per dwg A/R 4130 rod Batch: 118875 0.00

100 Large Fab

Large Fab

Large Fab

Memo 0.00

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

EL 11-11-30 KL

Ac 11-11-26

11.12.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				<u>W</u>	<u>11</u>	<u>12</u>	<u>01</u> (1)
120									
QC	Memo	0.00							
Quality Control									
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	Install paint screws on fitting ends								
	START TIME: <u>10:45</u>								
	OVEN TEMPERATURE: <u>320</u> °F								
	FINISH TIME: <u>11:15</u>								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

Handwritten: NO M-11/12/01

Handwritten: LASSY & M 11/12/01

Handwritten: W 118484

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>CA</i>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

11/12/02 @

11/12/15

11-12-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 76359

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Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 09/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issueECIPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049		Purchased	No			100	f	105.5500	4.3	4.526316			
M4130NT0 750W 049									**			<i>Ac 11.11.26</i>	
4130 RD Tube .750 x.049W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				105.55					
				117973				33.55					
				<u>118772</u>				72		<i>4.5263</i>			
M4130NT0.500W.049		Purchased	No			100	f	40.9100	4.3	4.526316			
M4130NT0 500W 049									**			<i>Ac 11.11.26</i>	
4130 RD Tube .500 x.049W													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT032				40.91					
				<u>110740</u>				40.91		<i>4.5263</i>			
M4130NT1.000W.120		Purchased	No			100	f	72.4200	1.5	1.578947			
M4130NT1 000W 120									**			<i>Ac 11.11.26</i>	
4130 RD Tube 1.00 x .120wall													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				72.42					
				117656				25					
				<u>117973</u>				47.42		<i>1.578947</i>			
D3016-17		Manufactured	No			100	Each	32.0000	2	2			
D3016-17									**			<i>Ac 11.11.30</i>	
Gusset													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				32					
				<u>70872</u>				20		<i>2</i>			
				70909				12					

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 76359

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Parent Item: D3016-041

D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 09/11/2011

Required Date: 25/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13 Manufactured No

100 Each 8.0000 2 2

D3016-13

Bracket

**

EL 11-11-30

Location

Loc Qty

Loc Code

WA

8

70015

8

D3016-15 Manufactured No

100 Each 9.0000 2 2

D3016-15

Gusset

**

EL 11-11-30

Location

Loc Qty

Loc Code

WA

9

73541

9

D3020-1 Manufactured No

100 Each 10.0000 4 4

D3020-1

Fitting

**

EL 11-11-28

Location

Loc Qty

Loc Code

WA

10

36713

1

70873

9

76579 x 2

W/O:		WORK ORDER CHANGES					
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76358
H.C.S.
11/11/09

DEO ATTACHED

RELEASED
01.05.30

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NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. A
#	#	D3016	SHEET 2 OF 3
DATE	TITLE		SCALE
01.05.18	SEAT FRAME ASSEMBLY		1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

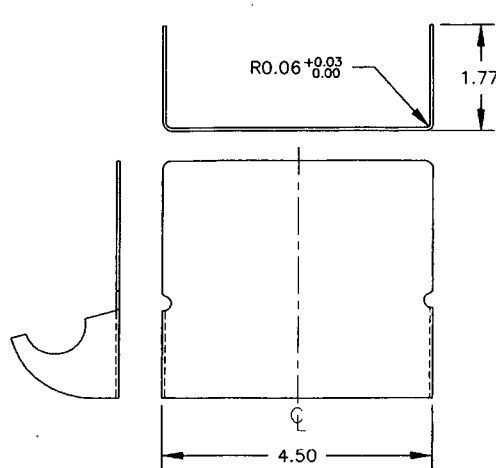
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

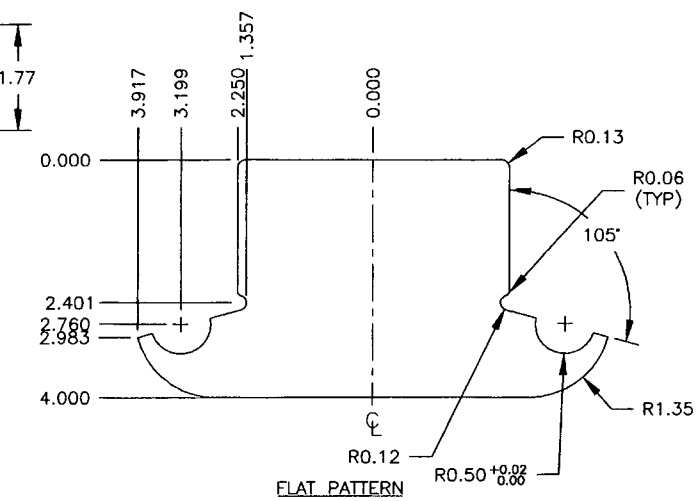
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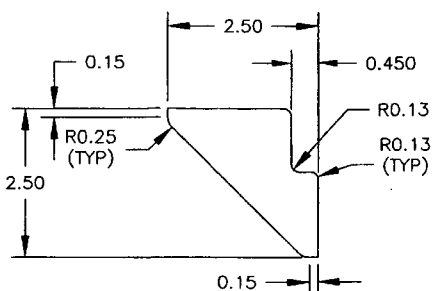


BENDING DETAIL

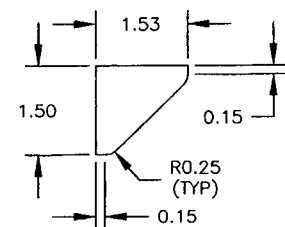


D3016-13 BRACKET

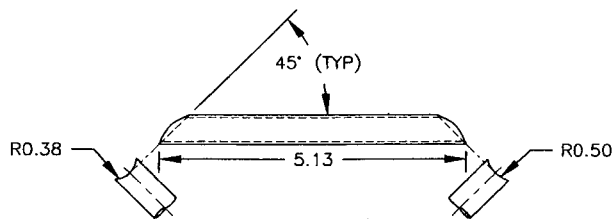
FLAT PATTERN



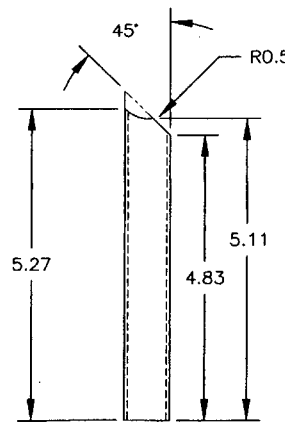
D3016-15 GUSSET



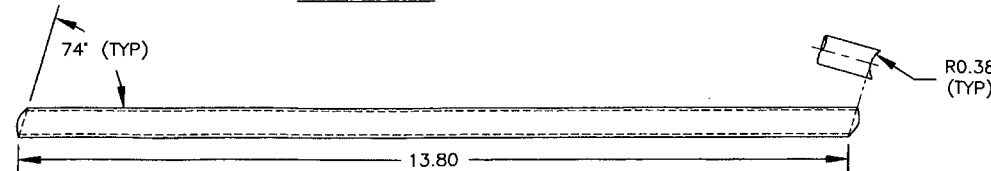
D3016-17 GUSSET



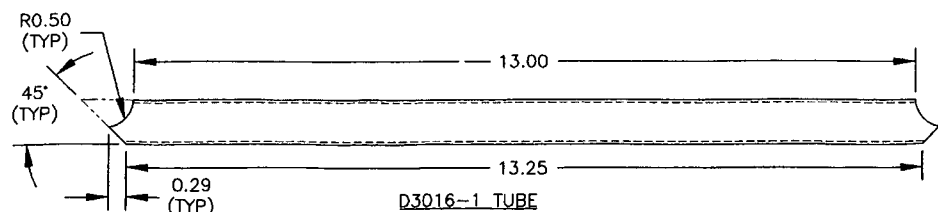
D3016-7 TUBE



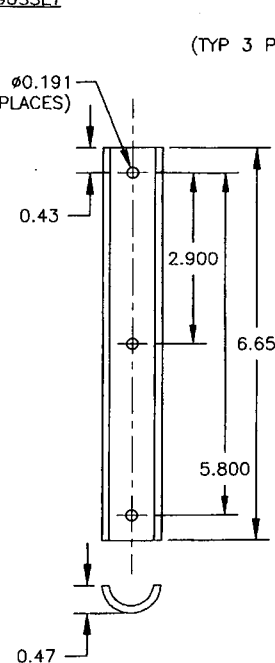
D3016-3 TUBE



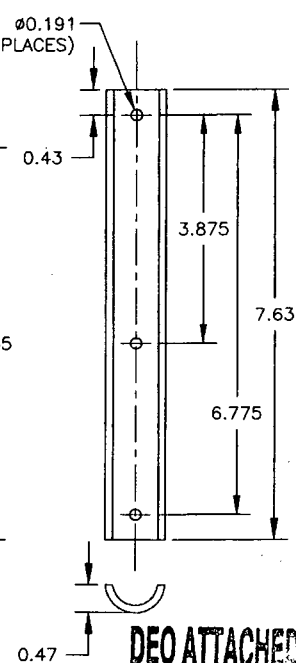
D3016-5 TUBE



D3016-1 TUBE



D3016-9 SADDLE



D3016-11 SADDLE

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DESIGN	CP	DRAWN BY	CP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SCALE	1:2

DEO ATTACHED
RELEASED
01.05.30

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WAP</i>	DE APPR. <i>TH</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

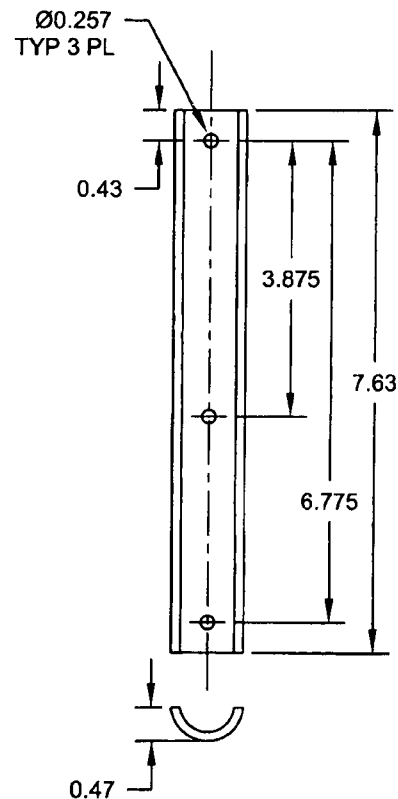
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

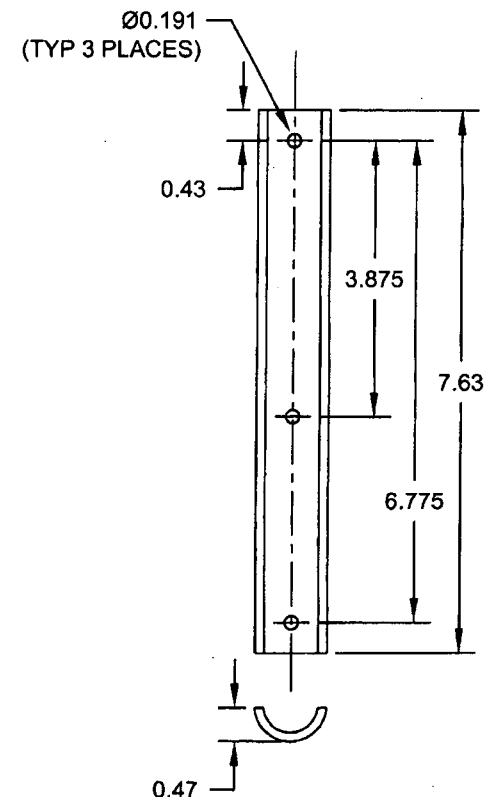
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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